

# Work Order ID 71627

Thursday, July 07, 2011 11:21:07 AM



Page 1

Item ID:	D3259-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Access Panel Assembly					
Start Date:	7/7/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	7/21/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>11-07-07</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3259	Rev B								

100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

*EP 11/09/20* (4)

110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble D3259-041 as per Dwg D3259 .(Note:Keep .040" Gap all around door.								

*EP 11/09/21* (4)

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

*8/11/09/21*

(4)

*-042*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 07, 2011 11:21:05 AM

Page 1

Work Order ID: 71627

Parent Item: D3259-042

Parent Item Name: Access Panel Assembly



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV  
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20470AD3-5  Rivet		Purchased	No			100	Each	3,892.000	10	40			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		3892							
				104817		3030							
				9682		862							
D3161-5  Hinge 9.9"		Manufactured	No			110	Each	14.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		14							
				47187		2							
				47773		12							
D3259-1  Panel		Manufactured	No			110	Each	1.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST180		1							
				60082		1							
D3259-4  Doubler		Manufactured	No			110	Each	0.0000	1	4			

*EB 11/09/20*

*EB 11/09/20*

*EB 11/09/20*

*B 71633 (4x)*

*B 71630 (3x)*  
*B 71680 (1x)*

*EB 11/09/20*

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Thursday, July 07, 2011 11:21:05 AM

Page 2

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Parent Item: D3259-042

Parent Item Name: Access Panel Assembly

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

D3259-5 Manufactured No



Spacer

110

Each

3.0000

1

4



Location

Loc Qty

Loc Code

ST180

3

60084

3

110

Each

1.0000

1

4



Location

Loc Qty

Loc Code

ST180

1

58751

1

110

Each

0.0000

2

8



D3260-1 Manufactured No



Spring

D3973-5



Receptable, Rigid, DZUS

Manufactured No

110

Each

68.0000

2

8



Location

Loc Qty

Loc Code

ST101

68

58759

68

110

Each

91.0000

2

8



D3974-20 Manufactured No



Stud, Wing Head, 5/16 DZUS

Location

Loc Qty

Loc Code

ST103

91

58761

66

61160

25

*EBH/09/20*

B71629 (4x)

*EBH/09/20*

B71632 (2x)

B71689 (2x)

B71631

(8x)

*EBH/09/20*

*EBH/09/20*

8

*EBH/09/20*

8

Thursday, July 07, 2011 11:21:05 AM

Shop Packet Print

Page 2

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Thursday, July 07, 2011 11:21:05 AM

Page 3

Work Order ID: 71627

Parent Item: D3259-042

Parent Item Name: Access Panel Assembly

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

MS20426AD4-4

Purchased

No

110

Each

2,452.000

4

16



Rivet

*ES 11/09/20*

Location

Loc Qty

Loc Code

ST317

2452

116188

2452

16

MS20470AD3-4

Purchased

No

110

Each

9,156.000

36

144



Rivet, Universal Head

*ES 11/09/20*

Location

Loc Qty

Loc Code

ST319

9156

111477

8332

15541

824

144

*11/09/20*

*13972-5*

*qty 2*

*B: 60452*

*ES 11/09/20*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

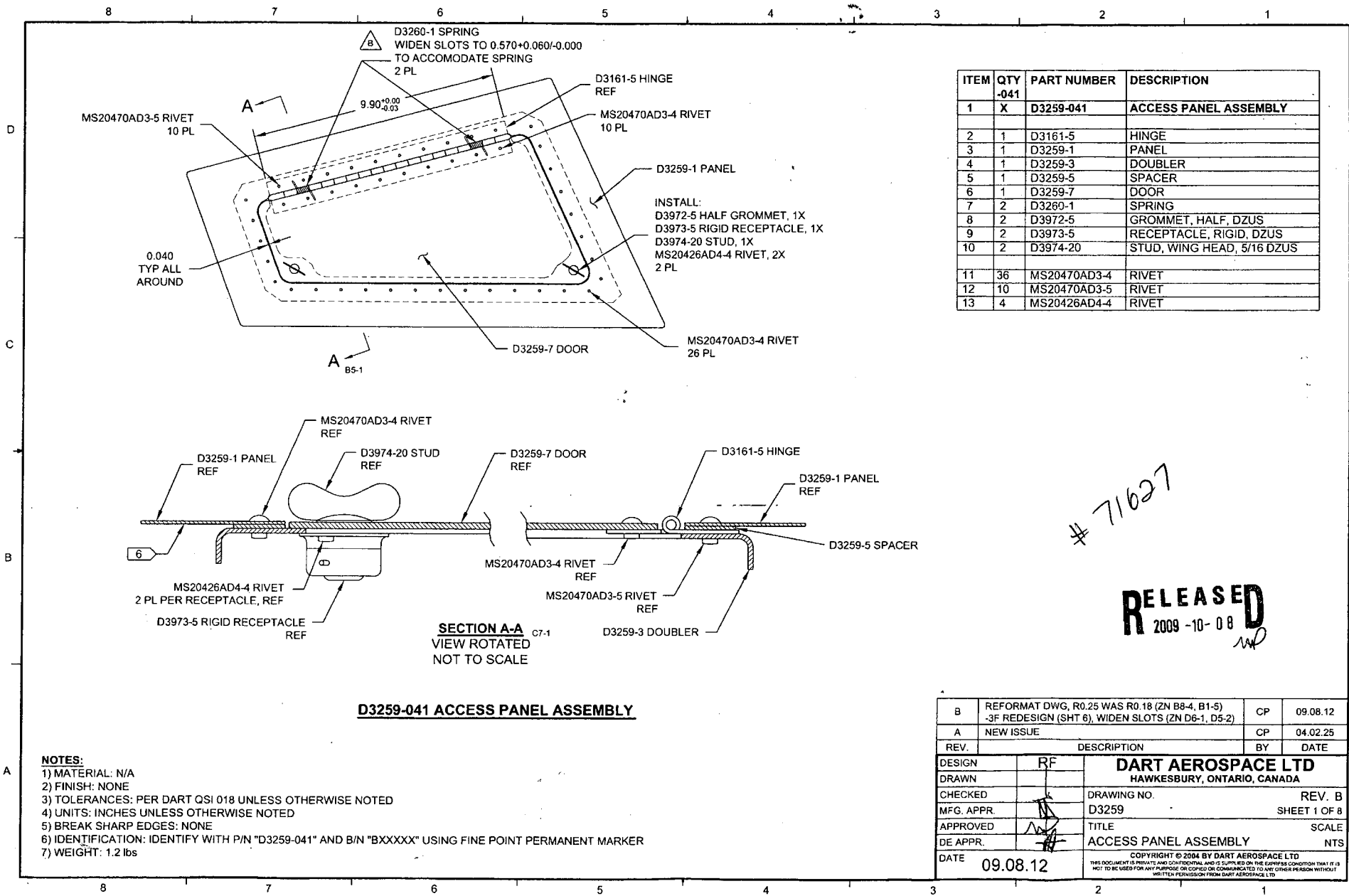
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





# 71627

**RELEASED**  
 2009-10-08

B	REFORMAT DWG, R0.25 WAS R0.18 (ZN B8-4, B1-5) -3F REDESIGN (SHT 6), WIDEN SLOTS (ZN D6-1, D5-2)	CP	09.08.12
A	NEW ISSUE	CP	04.02.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3259	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	NTS
DATE	09.08.12	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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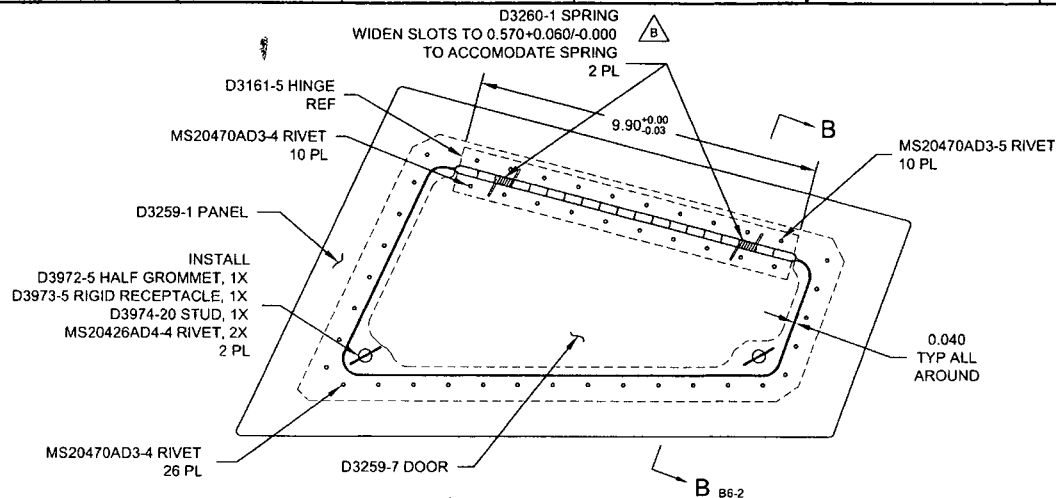
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

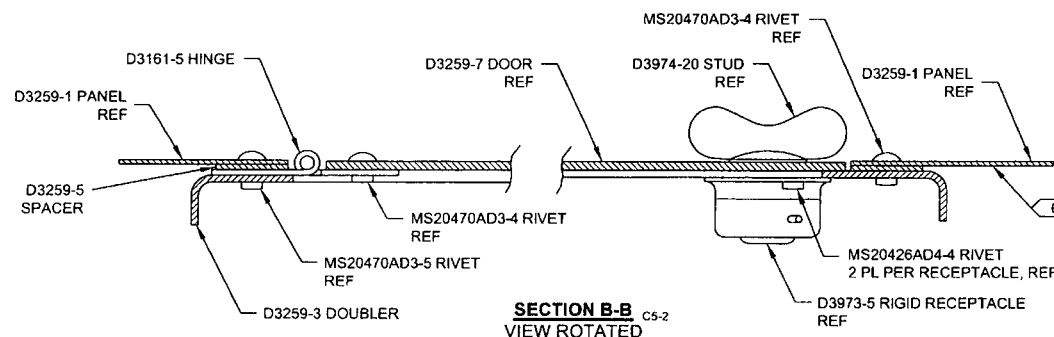
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-042	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-4	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



# **D3259-042 ACCESS PANEL ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

**RELEASED**  
2009-10-08

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3259	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

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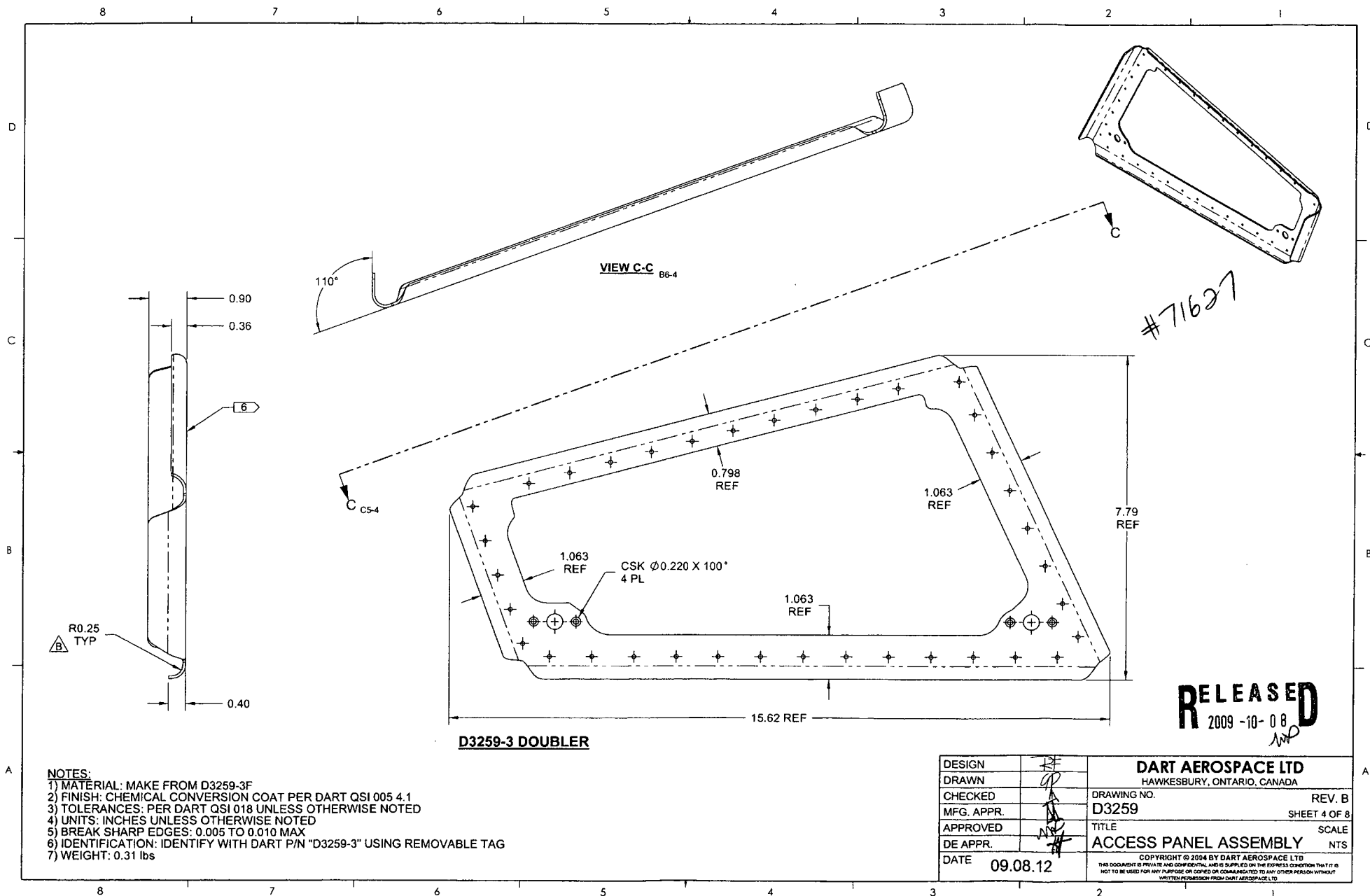
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**Dart Aerospace Ltd**

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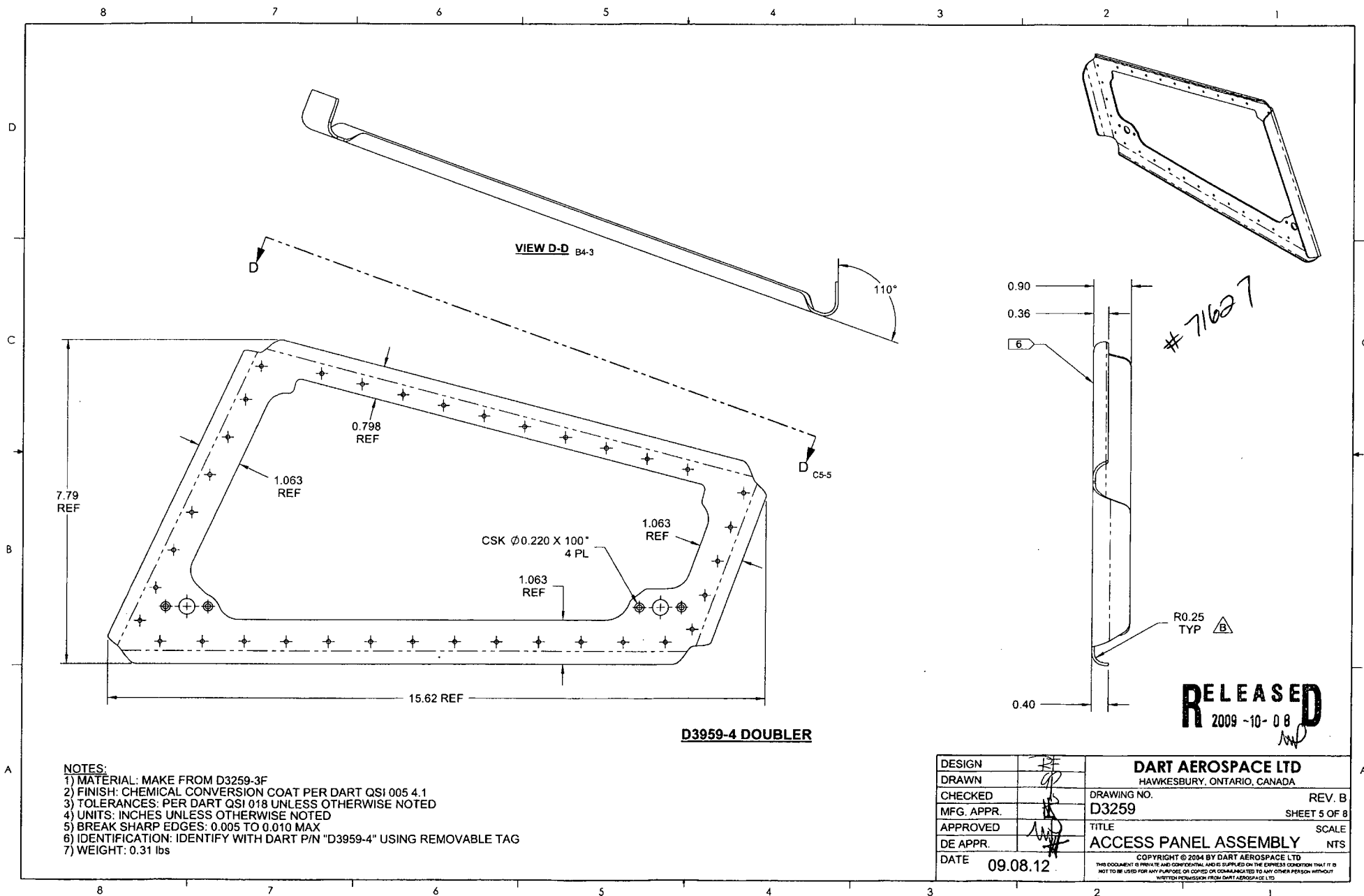
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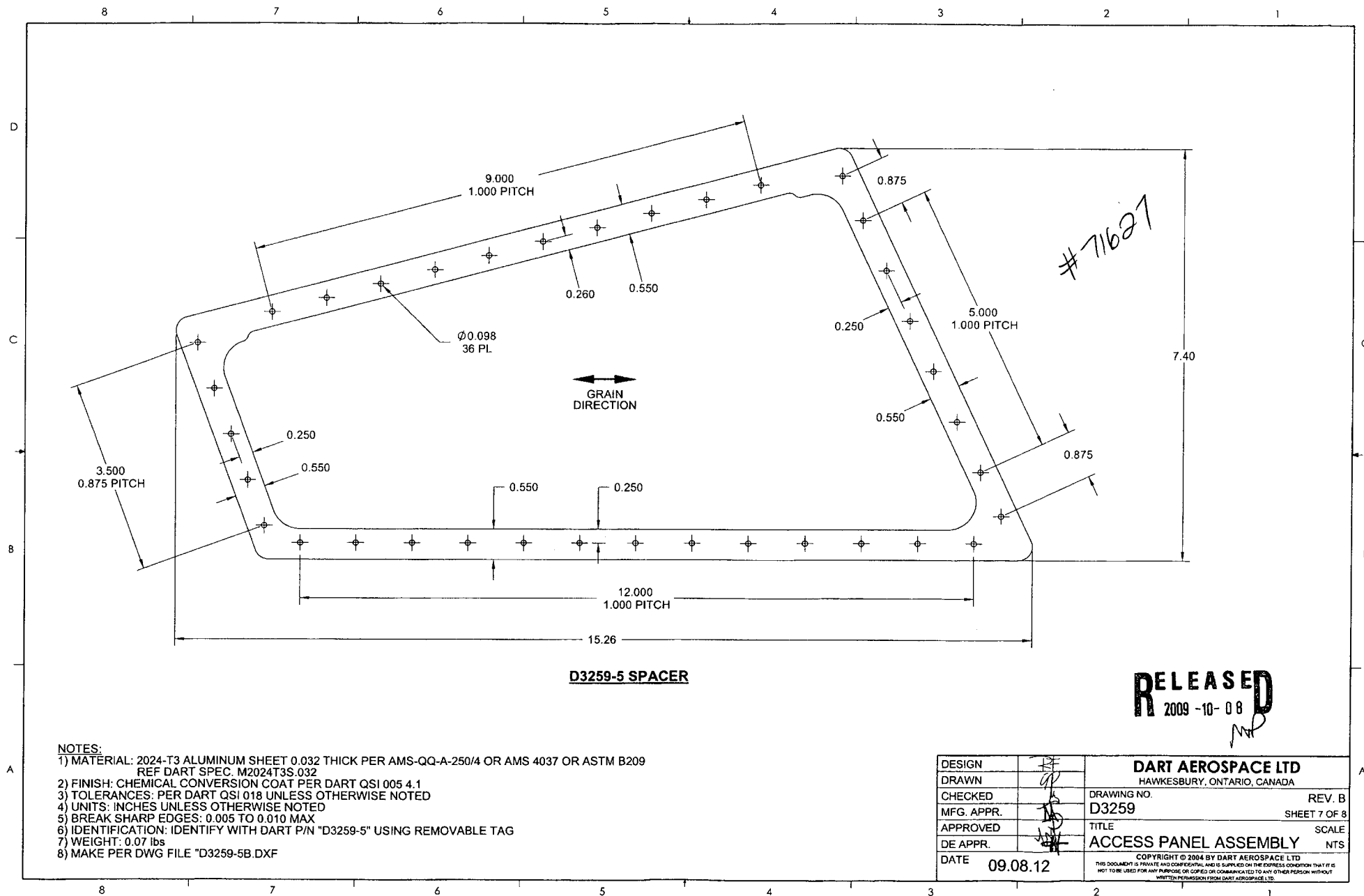
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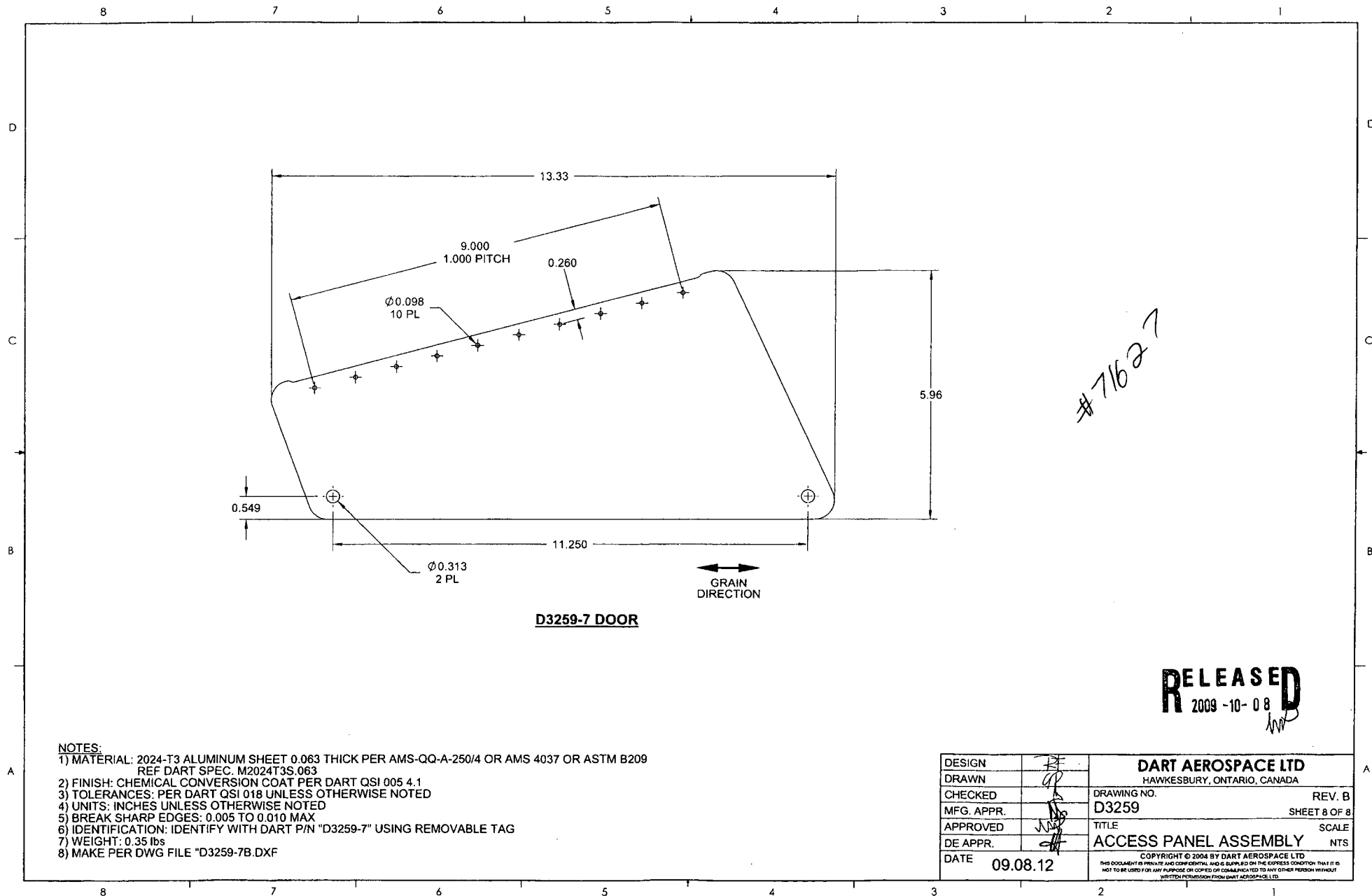
**Dart Aerospace Ltd**

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**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR: Yes No** **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

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**NOTE:** Date & initial all entries








**D3259-7 DOOR**

**RELEASED**  
2009-10-08

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
- 7) WEIGHT: 0.35 lbs
- 8) MAKE PER DWG FILE "D3259-7B.DXF"

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3259	SHEET 8 OF 8
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